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CENTRAL INTELLIGENCE AGENCY

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the First Quarter of 1949

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1. Present monthly ball bearing production in the Soviet Zone of Germany (end of 1948):
 - a. BERLIN: 5,000 ball bearings up to 62 mm in diameter,
 - b. RONNEBURG: 150 roller bearings ranging from 150 to 350 mm in diameter; and 150 repaired roller bearings ranging from 150 to 350 mm in diameter;
 - c. STADTILM: 8,000 tapered ball bearings 100 mm in diameter.
2. a. The following ball bearing production, scheduled for the first quarter of 1949, is to be attained through the installation of new machines in the ball bearing plants and by transferring machines from other plants to the ball bearing plants:

	January	February	March
Pieces			
In BERLIN	6,000	9,000	15,000
in RONNE-			up to 62 mm in diameter
BURG	200	250	
(M 51/K 16)			300 up to 350 mm in diameter
in STADTILM	9,000	9,000	9,000 tapered ball bearings up to 100 mm in dia-
(M 51/J 34)			meter.

Document No. 7

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b. It is also planned to start production of barrel-shaped ("fassformig") ball bearings in the FRAUENFELD/Thuringia Plant early in the second quarter of 1949. Detailed information on this project will be available by the end of January 1949 and will be listed in the production plan for the second quarter of 1949, which also provides for another ~~increase~~ in ball bearing production in the ball bearing plants listed.

3. The realization of this production plan will depend on the execution of the measures proposed in the annex:

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Comment:

a. [redacted] the FRAUENFELD Anti-friction Bearing Plant, which is scheduled to be so expanded as to become the largest Soviet Zone ball bearing and antifriction bearing plant, cannot resume its production before the second quarter of 1949. The key position of the FRAUENFELD Plant in the future Soviet Zone ball bearing production is revealed by the fact that it proposed the ball bearing production plan and the ball bearing plant requirement list of machine tools for the first priority program (first quarter of 1949) as well as for the entire year of 1949.

b. The total Soviet Zone ball bearing requirements are:

for the provincial plants	1,395,147 pieces
for the zonal plants	2,195,375 pieces
for the Soviet Corporation plants	5,034,000 pieces
total:	8,539,022 pieces

c. [redacted] a supply of about 700 machine tools is considered necessary for the realization of this production program. 70 machine tools are scheduled to be delivered from Nizonia, 23 from Czechoslovakia and more than 400 from Soviet Zone production.

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d. [redacted] THE ROHLSBURG Ball Bearing Plant supplies the "German Trade Company" in Berlin. The "German Trade Company", established by the German Economic Commission, is assigned to transact all German export deals in the Soviet zone of Germany. It can be therefore assumed that at least part of the ROHLSBURG ball bearing production is for export.

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e. The three Soviet ball bearing plants located in BOCHLITZ-SCHREIBERG, ZELLA-MEHLIS (M 51/J 03) and in MIRENTHAL-SCHWEINA (M 52/J 68) are not included in this plan, as these plants were turned into Soviet Corporation plants assigned to the "Avtovelo" Soviet Corporation in MOSCOW.

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[redacted] measures required for the realization of the proposed production plan for the first quarter of 1949.

2. machine tools for ball bearing production required by the end of 1949.

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Annex I

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measures required for the realization of the
Proposed Production Plan for the First Quarter of 1949.

- I. Drafting of a specified list for the ball bearing requirement of the German Trade Company, especially for the RONNEBURG ball bearing production.
- II. Supply or new installation of machines:
 - 1. In BERLIN:
 - a. 1 rough-turning machine ("Tusschneidemaschine") with aperture diameter up to 75 mm.
 - Present location: DÖHLEN (N 52/F 18) "Gusstahlwerk";
 - b. 2 Pittler automatic machines RP 64
 - Present location: CHEMNITZ (N 51/K 66) Miles Plant. At the disposal of the German Economic Commission;
 - c. 1 Pittler automatic machine, RP 42
 - Present location: "SKTB/4" (former "Pittler" Plant) in LEIPZIG (N 52/E 21). It would be urgently required to deliver all four Pittler automatic machines to BERLIN.
 - d. 4 special lathes
 - Present location: "Dorag" Plant in CHEMNITZ;
 - e. 1 surface circular grinding machine, 600 mm in diameter. Present location: "Jung" Plant in BERLIN. (The firm is willing to deliver the machine).
 - f. 1 surface grinding machine with long bench. Present location: Firm "Genzow" in BERLIN. (The firm is willing to deliver this machine).
 - g. 2 grinding machines for apertures ranging from 7 to 70 mm. Present location: Firm "Jung" in BERLIN. (The firm is willing to deliver this machine).
 - h. 1 eccentric grinding machine up to 30 mm in diameter. Present location: Firm "Genzow" in BERLIN. (The firm is willing to deliver this machine).
 - i. 1 circular grinding machine
 - with 100 mm center height)
 - ready for export
 - and 500 mm grinding length)
 - j. 1 shaping machine, 500 mm pass. Present location: Being manufactured by the "Mechanik" Plant in ROCLITZ (N 52/K 58).
 - k. 1 bow saw for materials up to 200 mm. Present location: Ordered by the "IKF" Firm at the "Göring and Severin" Plant in DRESDEN (N 52/F 29).
 - l. 2 furnaces for salt tub, diameter of crucible 500 mm. Present location: Being manufactured by the "Naumann" Plant in AUE/Erzgebirge (N 51/K 53).

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2. In RONNEBURG:

- a. 2 heavy lathes, center height: 300 mm.
Present location: 1 machine is at the "Fueckert" Furniture Plant in ZLULSENRODA (A 51/K 03) (The firm is willing to deliver the machine).
- b. 1 grinding machine for appertures up to 400 mm in diameter. Present location: Not indicated.
- c. 2 circular grinding machines, center height: 200 mm, grinding length: 500 mm. Present location: Not indicated.

3. a. The material for the inner and outer rings included in the BERLIN ball bearing production is available. The following types can be manufactured from this material:

6204 - 6205 - 62 06
6302 - 6303 - 6304 - 6305.

b. The material necessary for ball production must be imported, as all Soviet Zone stocks are exhausted. For the first quarter of 1949 approximately 2.5 tons of steel are required for the production of balls 13 mm in diameter.

c. Additional requirements for the first quarter of 1949:

1.5 tons of sheet iron, 1 mm gauge, only available through imports,
1.5 tons of brass,
65 kg of iron rivet wire for the production of rivets.

4. For the first quarter of 1949 the following material is required for the RONNEBURG production:

Approximately 40 tons of forged rings for new ball bearings
Approximately 15 tons of forged rings for repaired ball bearings
6 tons of round material for rolls
6 tons of brass for solid ball cages
120 kg of rivet wire, 6 mm gauge.

Final requirement applications for raw materials cannot be made until the order of the German Trade Company has been received.

5. The material needed for the STADTILM ball bearing production in the first quarter of 1949 is available.

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Annex 2

Machine Tools for the Ball Bearing Production Required by
the End of 1949

1. Machine tools, which can be delivered from the current Soviet Zone production:

Number of Units	Designation of Machine	Dimensions	Supplying Firm
14	turret lathes	30 mm passage	"Ragema" Plant in CHAMINITZ(N 51/K 66)
3	automatic saw	25 mm in diameter	"Fr. Irmischer" in SAALFELD (M 51/J 53)
17	automatic saw	120 mm in diameter	"Fr. Irmischer" in SAALFELD (M 51/J 53)
3	cold bow saws	160 mm in diameter	"Gornig u. Severin" in DRESDEN
2	cold bow saws	250 mm in diameter	"Gornig u. Severin" in DRESDEN
12	surface grinding mach. 1,000 mm surface		"Billeter u. Klunz" in ASCHERSLEBEN (M 52/D 55)
14	surface grinding mach. 630 mm surface		"Billeter u. Klunz" in ASCHERSLEBEN
4	surface grinding mach. ?		"Samson" in DRESDEN
14	surface grinding mach. 500 x 200 mm bench surface		"Samson" in DRESDEN
1	vertical grinding mach. 300 x 700 mm bench surface		"Billeter u. Klunz" in ASCHERSLEBEN
3	four spindle automatic machines	25 mm passage	"Niles-Werke" in CHAMINITZ
4	four spindle automatic machines	42 mm passage	"Niles-Werke" in CHAMINITZ
2	four spindle automatic machines	64 mm passage	"Niles-Werke" in CHAMINITZ
4	circular grinding mach. 100 x 500 mm) " " " " 110 x 400 mm)		"Werkzeugmaschinen-Fabrik" in HARTMANNSDORF(N 51/K 35)(Machine Tool Plant)
2	universal circular grinding machine	110 x 400 mm	the same
2	eccentric presses	10 tons }	
5	eccentric presses	15 tons }	
1	hand press	5 tons }	"Eisenwerk" (Iron-works) "Lorzenroete"
30	polishing machines	-	"Werkzeugmaschinen-Fabrik Alemannia" in DRESDEN

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Number of Units	Designation of Machine	Dimensions	Supplying Firm
6	"Duprex" universal milling machines	-	"Thiel" Soviet Corporation Plant in RUMLA (N 51/H 35)
11	riveting machines	up to 3 mm	W. UHLAND,
7	riveting machines	ranging from 2 to 4 mm	LEIPZIG
2	riveting machines	ranging from 3 to 6 mm	
8	lathes with draw spindle and lead screw	180 x 500 mm	Kaeger, BERLIN
5	lathes with draw spindle	280 x 1,000 mm	"Chennitzer Drehbankbau", CHENNITZ
2	lathes with draw spindle	225 x 1,000 mm	the same
9	lathes with draw spindle	250 x 1,000 mm	the same
1	lathes with draw spindle	300 x 2,000 mm	the same
5	horizontal milling machine	250x300 mm	Arno Krebs, LEIPZIG
3	vertical milling machine	200 x 630 mm	"Werkzeugmaschinen-Fabrik" in MITTELWEIDA (N 51/K 67)
5	column drilling machines	up to 25 mm	Hille-Werke, DRESDEN
4	column drilling machines	up to 40 mm	the same
3	column drilling machines	up to 63 mm	the same
7	bench drilling machines	up to 10 mm	"Werkzeugmaschinen-Fabrik" in MAGDEBURG (N 53/Y 60)
4	shaping machines	400 mm	"Werkzeugmaschinen-Fabrik" in ROCHLITZ
1	shaping machines	630 mm	"Lange u. Geilen, HALLE/Saale (N 52/D 92)
1	vertical slotting machine	12 x 12 steel cutting	"Roscher u. Sichler"
1	sawing machine	-	"Thiel, Soviet Corporation Plant, RUMLA
7	grinding machines	200 mm disk diameter	"Meier u. Weichelt", LEIPZIG
10	grinding machines	300 mm disk diameter	"Meier u. Weichelt", LEIPZIG
2	rough-turning machines (Ausschaelmaschinen) (New constructions)	up to 80 mm diameter	"Niles-Werke", CHENNITZ
13	pipe cutting machines (new constructions)	110 to 120 mm diameter	M. Hartensteiner?

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Number of Units	Designation of Machine	Dimensions	Supplying Firm
165	lathes for turning rings (new constructions)	250 to 400 mm in diameter	Fischer, FRALIT (N 52/F 18)
25	circular grinding machines	150 x 500 mm	Reinicke-Jenke, COTTBUS
12	circular grinding machines with device for radial adjustment	150 x 500 mm	" " "
3	the same	200 x 500 mm	" " "
2	the same	150 x 750 mm	" " "
5	the same	250 x 500 mm	" " "
30	internal grinding machines	up to 70 mm	" " "
10	internal grinding machines	up to 250 mm	" " "
6	universal circular grinding machines	135 x 1,000 mm	" " "
5	instrument grinding machines for "Rasvertki" milling cutters (new constructions)	?	" " "
3	steel grinding machines	40 x 40 mm	" " "
35	interior grinding machines	up to 70 mm	Jung, BERLIN
20	the same	up to 250 mm	Jung, BERLIN
33	the same	up to 150 mm	Wotan u. ZILLER-mann, GLAUCHAU (N 51/K 35)
404	machine tools delivered from the current Soviet Zone production.		

Machine Tools to be Delivered from Bizonia:

Number of Units	Designation of Machine	Dimensions	Supplying Firm
1	turret lathe	82 mm passage	Boehringer, GOETTINGEN (L 49/S 41) (?)
16	centrifuges for circular grinding machines	-	Schmalz, OFFENBACH/Main (L 51/N 76)
23	eccentric grinding machines	up to 120 mm	from the SCHWEINERT (L 51/N 76) "SKF" Plant in exchange for barrel-shaped roller bearings

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Number of Units	Designation of Machine	Dimensions	Supplying Firm
2	four-spindle automatic machines	75 mm interior radius(?) " " "	Schmitz, OFFENBACH/Main
10	grinding machines for apertures with a device for cleaning the radium	"IRS" 1 to 150 mm	
6	the same	interior radius(?) " " "	
6	"belt" grinding machines for lengthwise hollowing with turning device	up to 200 mm	" " "
2	the same	up to 400 mm	" " "
1	hydraulic flat pressing machine	bench diameter: 500mm bench diameter: 300mm	Hahn u.Kolb, Index-Werke, ESSLINGEN (L 49/S 11)

70 machine tools to be delivered from Bizonia.

3. Machine Tools to be Delivered from Czechoslovakia

23 eccentric grinding machines up to 120 mm passage Czechoslovakia

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